

Date: Wednesday, 5/31/2006 10:14:07 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 BASKET LID (SHORT)
 Job Number : 27293B
 Estimate Number : 10210
 P.O. Number : NIA Part Number : D3266041
 This Issue : 5/31/2006 S.O. No. : NIA Drawing Number : D3266-041 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : 5/31/2006 Type : LARGE FAB ASSY Drawing Revision : A1
 Previous Run : 27292B Material : NIA
 Due Date : 6/30/2006 Qty: 1 Um: Each
 Written By : *See Summary Below*
 Checked & Approved By : *06-05-31*
 Comment : Est Rev:B Re-Format 05-11-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31663 Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty 1 D3166-3 Basket Hoop Batch: *B25.503*

PD

06-06-08

2.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 28.3500 f(s)/Unit Total : 28.3500 f(s)

3/4" x 3/4" square tubing as per Dwg D3266 Material: 304/316 SS tube .063" wall(

M304TS0.750W.065)

Batch: *M100783 -> 210.59" M10111 -> 112.26"*

PD

06-06-12

3.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B25238

PD

06-06-12

4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushings

B26742

PD

06-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 10:14:08 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET LID (SHORT)

Job Number: 27293B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2506

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

B26631-2

PD

06-06-12

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B26204

PD

06-06-12

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 10.0000 sf(s)/Unit Total : 10.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

10sf M304EX0.75-16F

Expanded Metal

M100981

PD

06-06-14

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236 From D3166-3

2-Cut 3/4" x 3/4" square tubing as per Dwg D3266

3-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305

4-Deburr & Remove all markings from material

5-Weld as per Dwg D3266 using Welding Table and corner Jig Deburr as required

PD

06-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/06/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 27293B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DL 06/09/06 (1)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/20 (1)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Batch: M101266
and Spray Paint black Batch: M101032
as per Dwg D3266and QSI 005 4.4

DL 06/06/22 (1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

DL 06/06/22 (1)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/06/27 (1)

Job Completion



DL 06-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

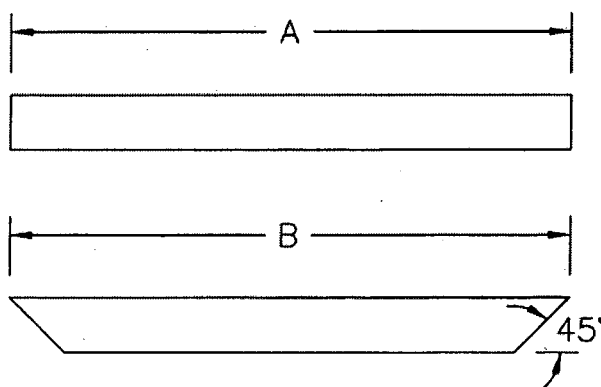


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3266	REV. A SHEET 1 OF 4
DATE 04.02.02		TITLE BASKET LID ASSEMBLY (350)	SCALE NTS
A	04.02.02	NEW ISSUE	
AI	<i>[Signature]</i> 04.09.20	TACK WELD ANTI-SKID AREA	

RELEASED
04.02.10 *[Signature]*

PARTS LIST FOR D3266-041 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3266-1	2	—	25.50	RIB
D3266-3	2	—	56.17	RIB
D3266-5	6	11.27	—	RIB
D3266-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D3266-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO. **27293B**

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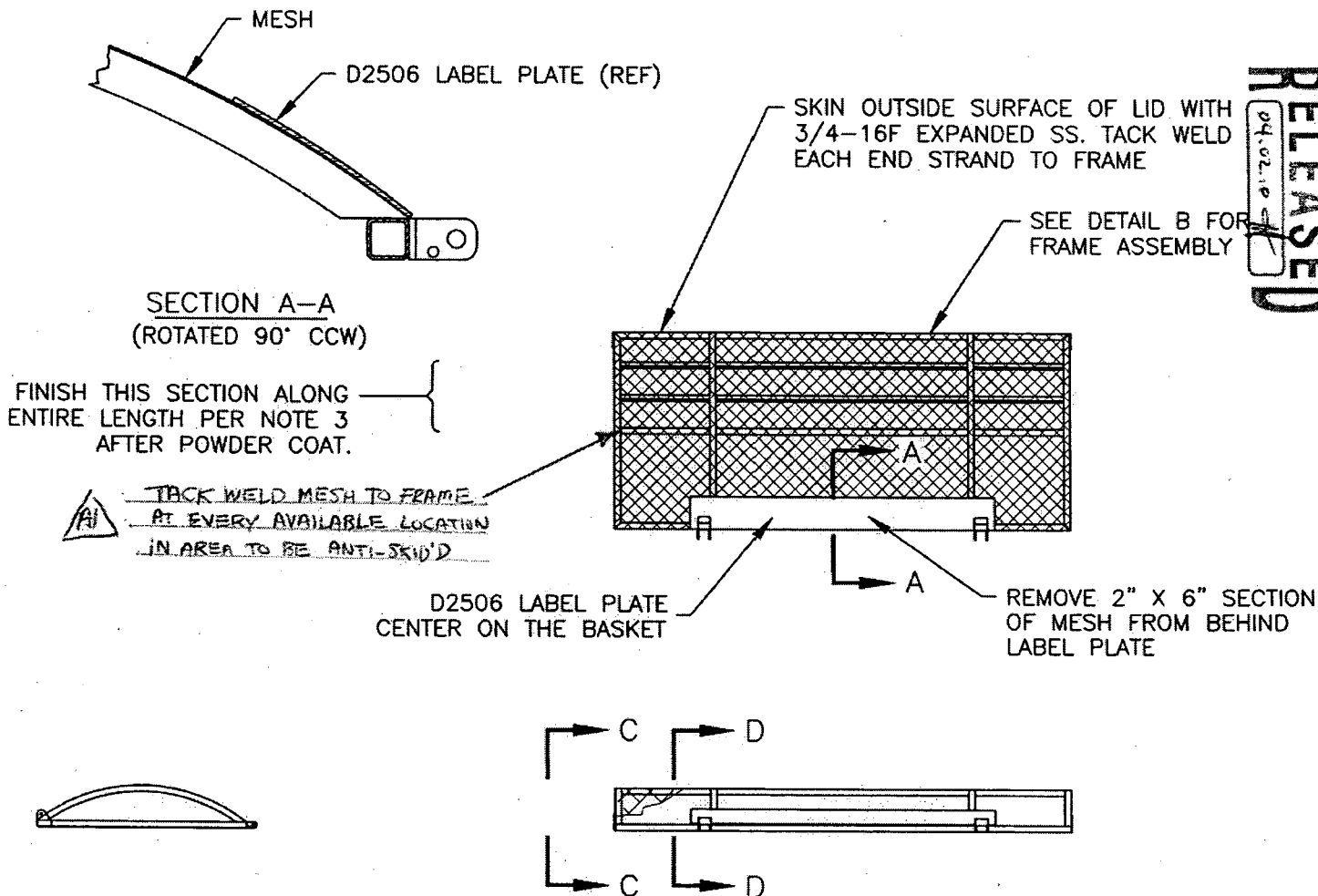
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CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3266	SHEET 2 OF 4
04.02.02		TITLE	SCALE
		BASKET LID ASSEMBLY (350)	1:20

RELEASED
04.02.10



D3266-041 BASKET LID ASSEMBLY

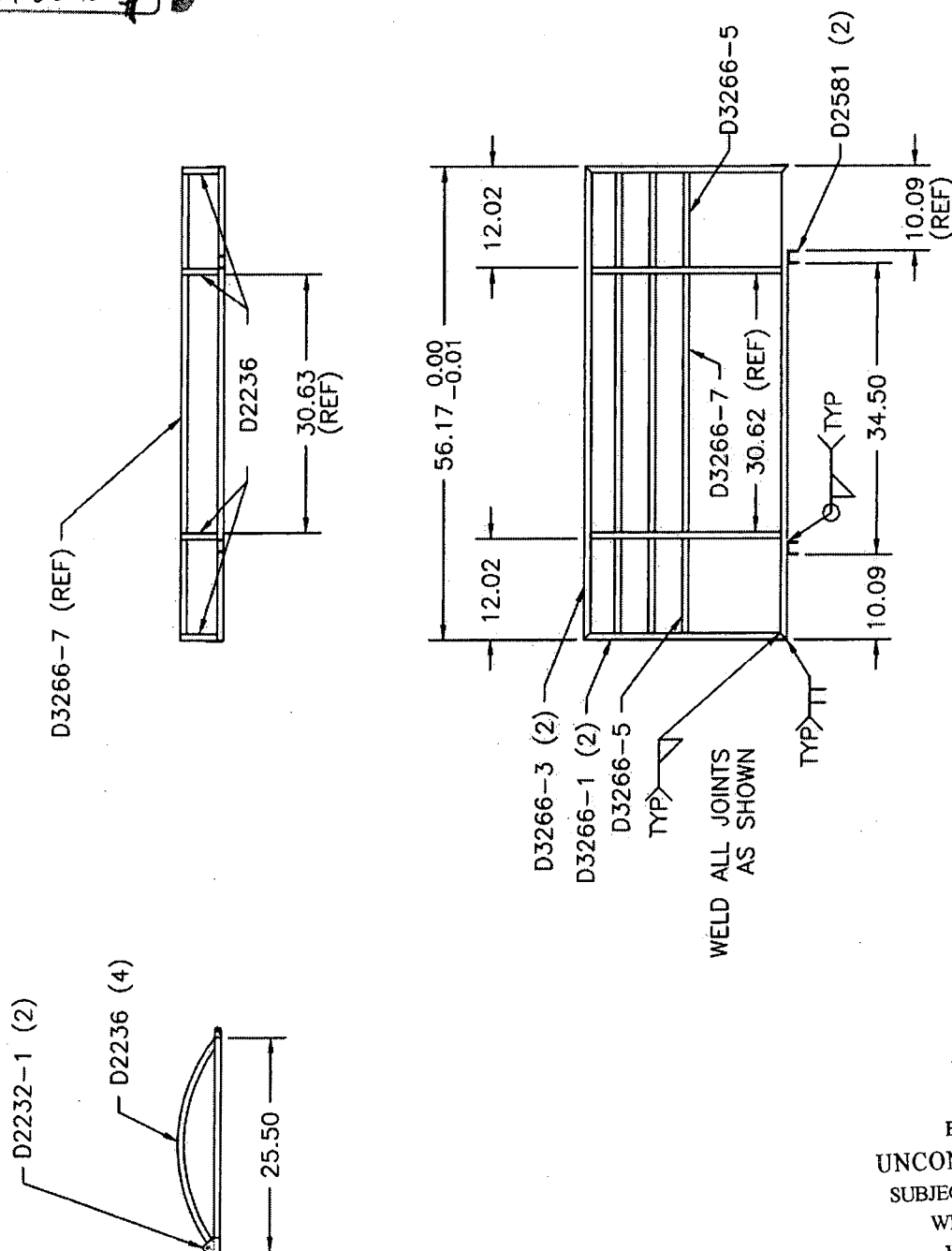
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DATE 04.02.02		TITLE BASKET LID ASSEMBLY (350)	SCALE 1:20

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04.02.10



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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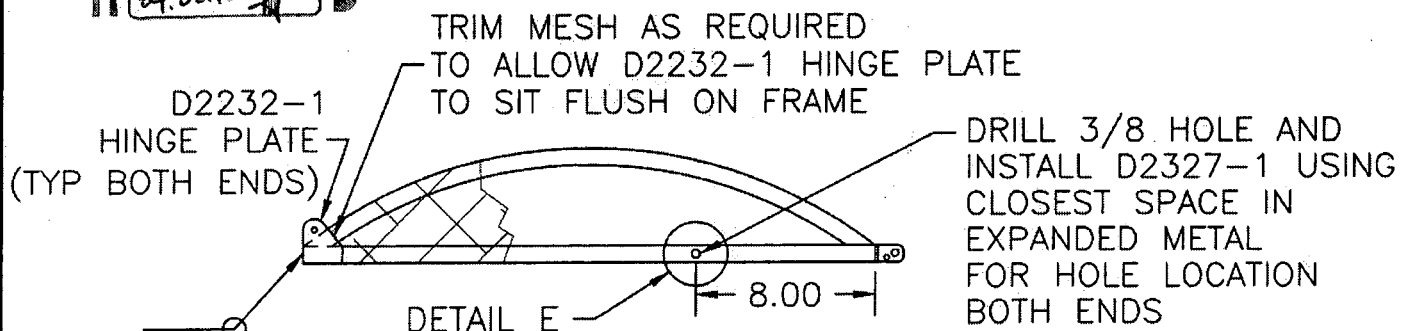
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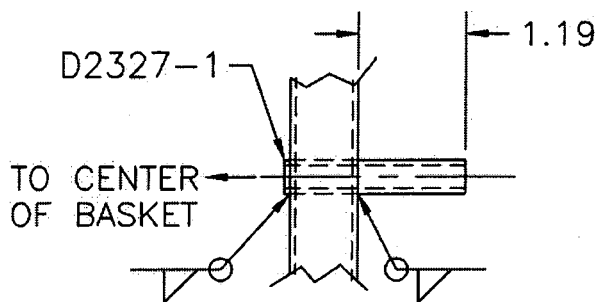


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DATE 04.02.02		TITLE BASKET LID ASSEMBLY (350)	SCALE 1:8

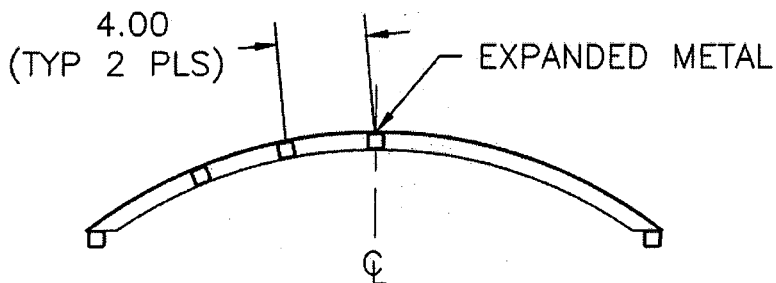
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04.02.10 #



SECTION C-C SIMILAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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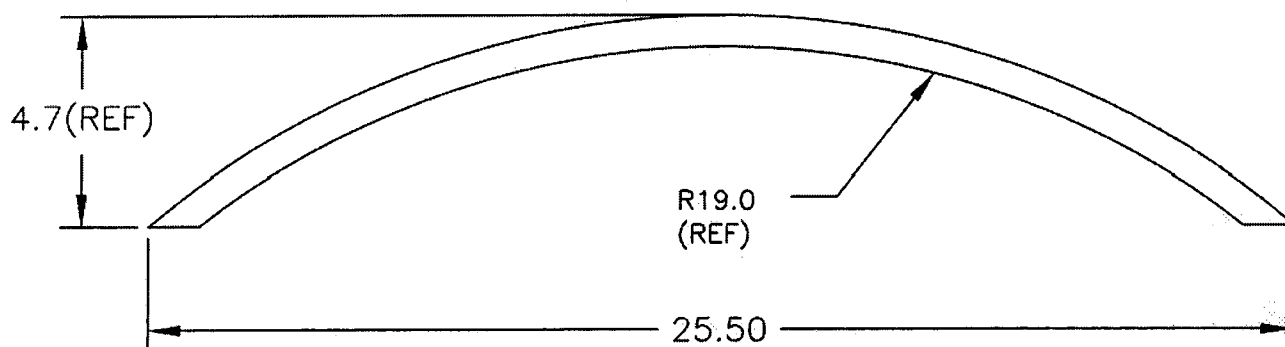
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DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2236	REV. C SHEET 1 OF 1
DATE 05.06.07		TITLE LID RIB	SCALE 1:4
A	94.05.30	NEW ISSUE	
B	94.12.16	LID	
C	05.06.07	UPDATE NOTES, CHANGE RADIUS TO 19.0	

RELEASED

05.08.19 #



D2236

D2236 LID RIB

- 1) MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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